

606156 5/8

Work Order ID 151971

Friday, October 14, 2016 1:56:19 PM

151971

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Item ID: D2594-1 **Accept** ***N900040100*** **Setup** **Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Plug
Start Date: 10/11/2016 **Start Qty:** 100.00 ***100*** **Cust Item ID:**
Required Date: 10/14/2016 **Req'd Qty:** 100.00 ***100*** **Customer:**
Reference:

Approvals: **Process Plan:** DAS 21 9-89 **Date:** OCT 17 2016 **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2594	Rev C

100	Hardinge CNC LATHE SMALL	0.06							
100									
Hardinge	Memo	0.33							
Hardinge CNC Lathe Small	1-Make as per Dwg D2594-1 and Folio FA262.2-Break all sharp edges 0.010 max.								

DAS
 45 16-10-25
 9-89

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.17							
Quality Control									

DAS
 45 16-10-2
 9-89

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.33							
Quality Control									

DAS
 45 16-10-26
 9-89

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Item ID: D2594-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plug
Start Date: 10/11/2016 Start Qty: 100.00 ***100*** Cust Item ID:
Required Date: 10/14/2016 Req'd Qty: 100.00 ***100*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.17				<u>X101</u>	<u>10</u>	<u>7016/10/26</u> <u>3EB</u>	
140 *140* Powdercoat Powder Coating	White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum <u>M 134498</u> Memo START TIME: <u>3:25</u> OVEN TEMPERATURE: <u>325</u> FINISH TIME: <u>3:55</u>	0.00 0.17				<u>101</u>	<u>16-10-26</u>	<u>348</u>	
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.17				<u>101</u>		<u>DAS</u> <u>38</u> <u>9-28</u> <u>OCT 27 2016</u>	

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Picklist Print

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Work Order ID: 151971

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Parent Item: D2594-1

D2594-1

Parent Item Name: Plug

Start Date: 10/11/2016

Required Date: 10/14/2016

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP D02.08.22Make in CobraKJ
IPP E 06.12.11 ecn 836 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased				110	f	36.9800	0.0521	5.484211			

M6061T6R0 625

6061-T6 Round Bar .625"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT005	24	
m135779	24	
MAT012	12.98	
m134284	3.32	
<u>m135377</u>	9.66	

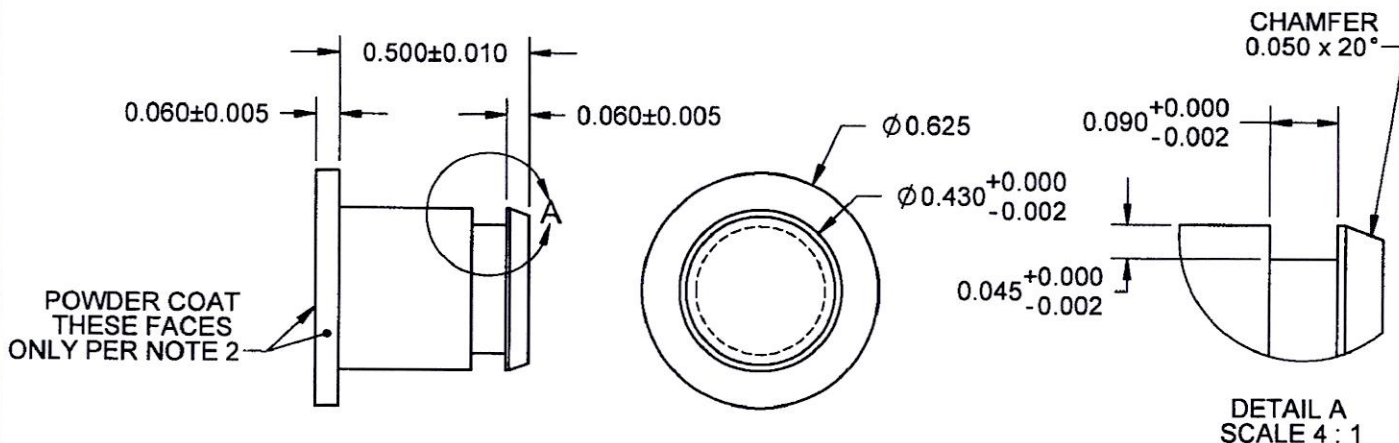
6.3 Ft

DAS
45 10-10-25
9-89



DESIGN <i>HA</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>HA</i>	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20		TITLE PLUG	SCALE 2:1
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASE
06.11.28 *HA*



D2594-1 PLUG

D2594-1 PLUG NOTES:

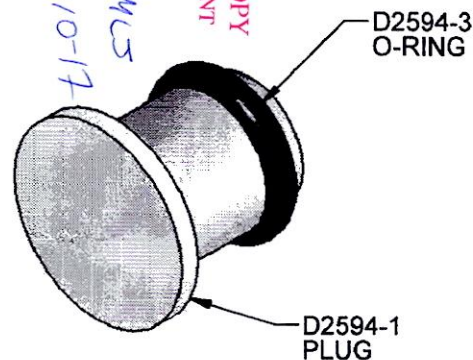
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



D2594 PLUG ASSEMBLY

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